

Work Order ID 80341

80341

Page 1

February-17-12 8:33:14 AM

Item ID: D3564-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 17/02/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: <u>D</u> Prog								
<u>304, 083</u>	Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

W 12-03-01 (12)

W 12-03-01 (12)

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130						(12)			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179			SB 12/03/08					
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(X12)			
QC	Memo	0.00		5/12/03/08					
Quality Control									
150	Large Fab	0.00							
150						(X12)			
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 2059B Hardcoat								
	m/20392 Weld hardcoat as per Dwg D3437								

(X12) ME/MAL 2012/03/22
~~22-03-20~~

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 Required Date: 02/03/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00		PC12.03.22		12x	Ø		
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 12/13/23		(412)			
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3 M118489 Memo START TIME: 1:15 OVEN TEMPERATURE: 325 FINISH TIME: 1:45	0.00 0.00				12	12 12 22		

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FPI</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

X12 d JU n103/26
 ROUTED - MCAS VECT

12 Q 12/03/26

MCJ 12/03/26

12-03-26

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NOTE: Date & initial all entries

Picklist Print

February-17-12 8:33:18 AM

Page 1

Work Order ID: 80341

80341

Parent Item: D3564-11

D3564-11

Parent Item Name: Wearshoe

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	58.0000	1.41	17.81053			

M304S16GA

304/316 Sheet .063

**

W 12.03.01

Location

Loc Qty

Loc Code

MAT020

58

119653

58

120866

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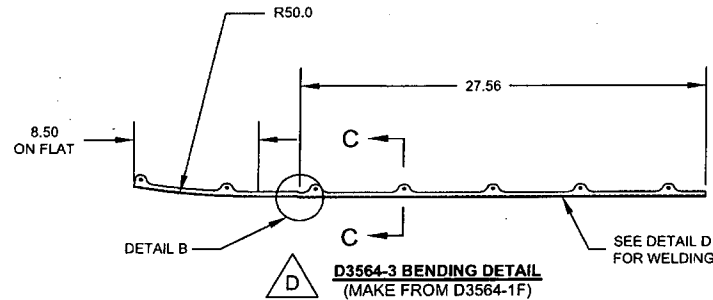
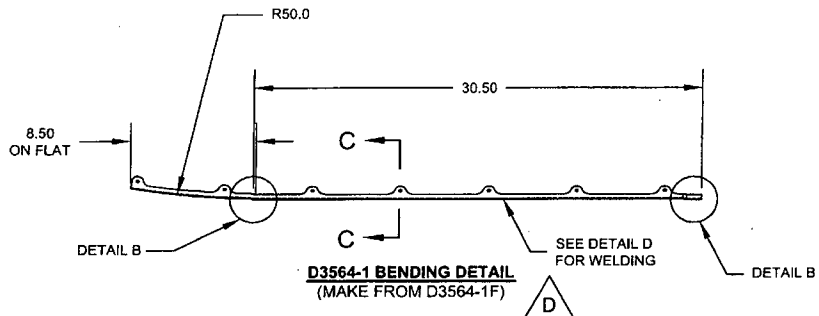
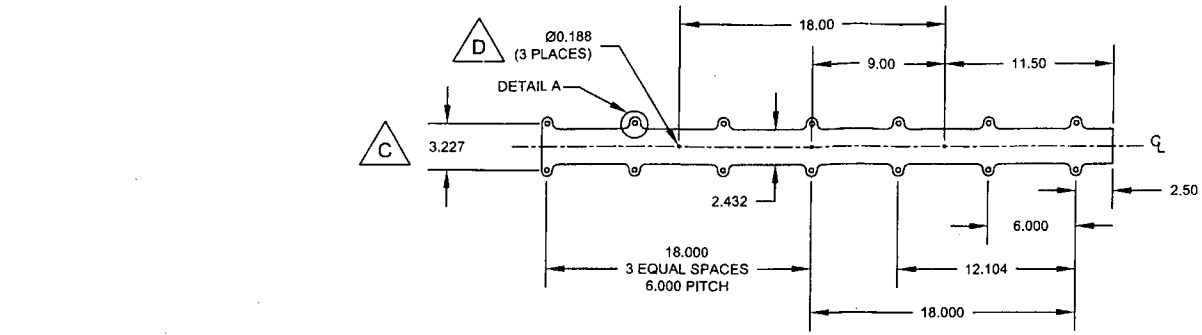
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80341 M.L.J

RELEASED

12/02/17

07.09.04

D3564-1F FLAT PATTERN



UNDER REVIEW
11-10-17
First change
OK 9/11/17

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5, C5; ADD D3564-15; PG1 B6, B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3; D3564-9/-11 WAS ON PG1; PG3 B8, C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2; RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. D D3564 SHEET 1 OF 3 TITLE SCALE WEARSHOE 1:8	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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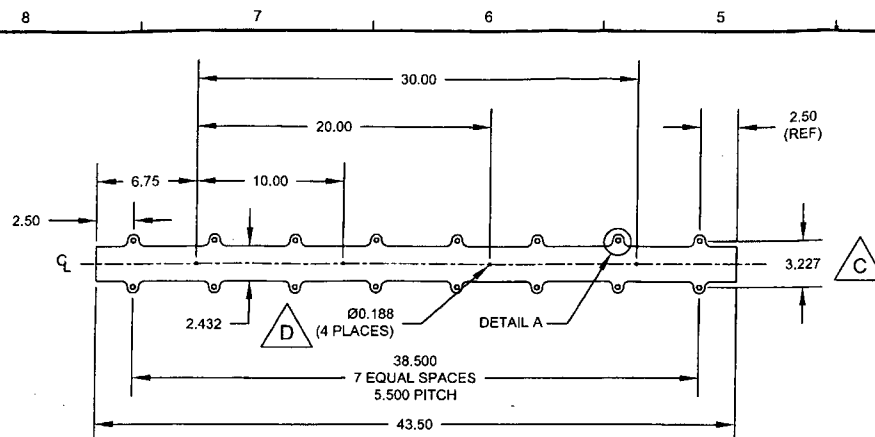
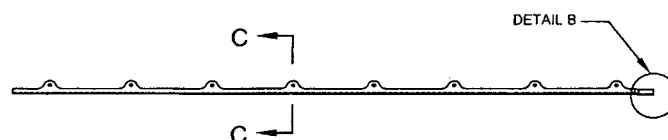
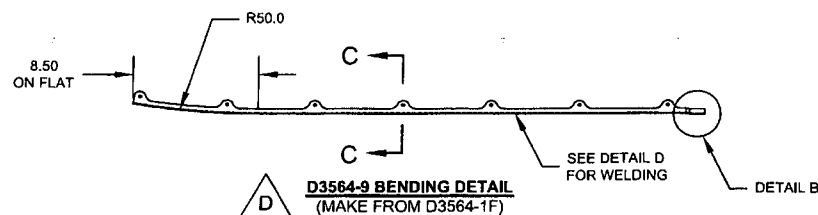
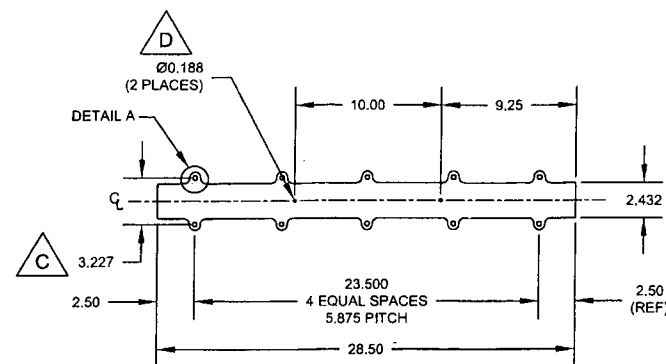
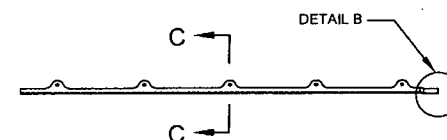
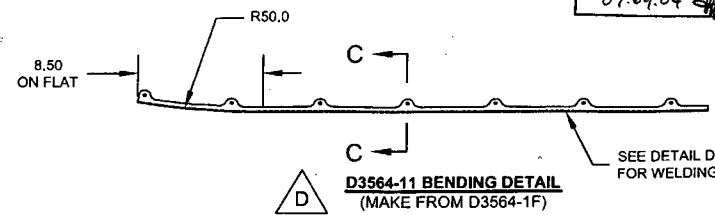
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**D3564-5F FLAT PATTERN****D3564-5 BENDING DETAIL**
(MAKE D3564-5 FROM D3564-5F)**D3564-9 BENDING DETAIL**
(MAKE FROM D3564-1F)**D3564-7F FLAT PATTERN****D3564-7 BENDING DETAIL**
(MAKE D3564-7 FROM D3564-7F)**D3564-11 BENDING DETAIL**
(MAKE FROM D3564-1F)RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. I
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

UNDER REVIEW
OK 07.11.28

Dart Aerospace Ltd

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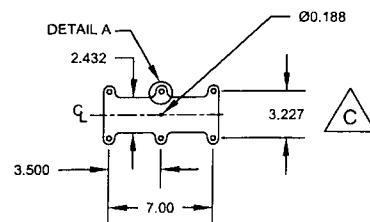
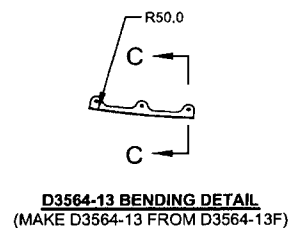
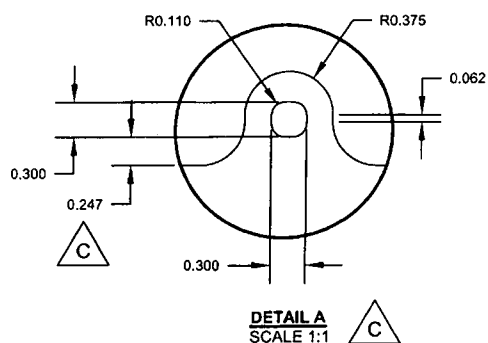
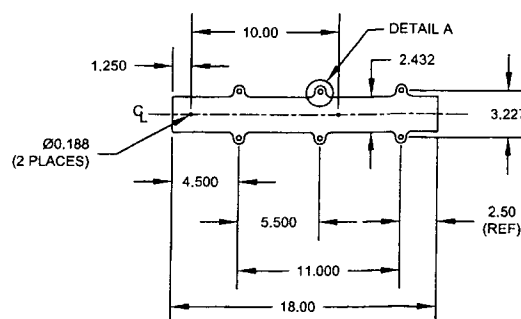
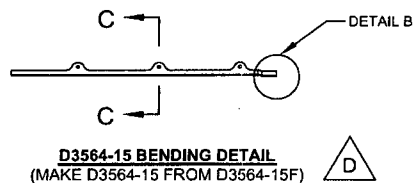
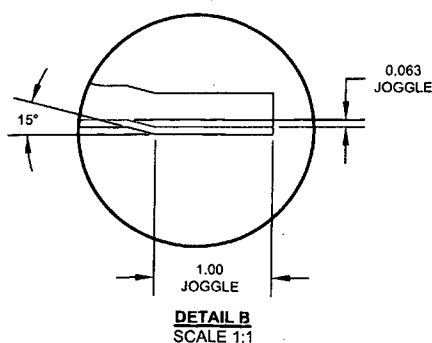
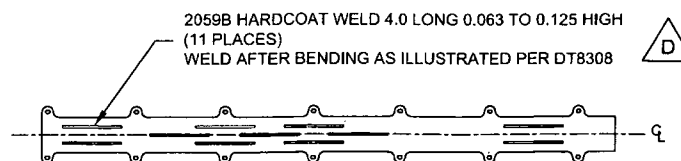
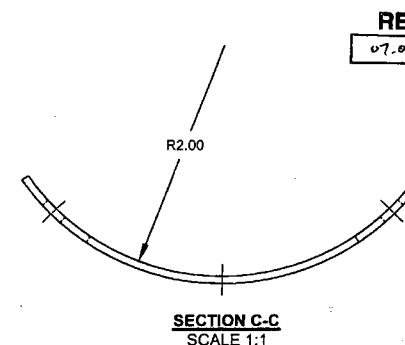
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**D3564-13F FLAT PATTERN****D3564-13 BENDING DETAIL**
(MAKE D3564-13 FROM D3564-13F)**DETAIL A**
SCALE 1:1**D3564-15F FLAT PATTERN****D3564-15 BENDING DETAIL**
(MAKE D3564-15 FROM D3564-15F)**DETAIL B**
SCALE 1:1**DETAIL D**
(D3564-1/-3/-9/-11 WELDING DETAIL)**SECTION C-C**
SCALE 1:1RELEASED
07.09.04UNDER REVIEW
OK 07.11.28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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